

ABSTRACT

The inventive system and method allows the control of shielding gas in an electric welding apparatus having automatic wire feed by controlling the flow rate of the shielding gas as a function of the wire feeding speed and/or the welding current obtained. A control circuit 112 receives an input signal 203 that is representative for the wire feeding speed and/or the welding current, and issues, in response to the input signal 203, a control signal 206 to a controllable flow control valve 110 in a gas supply line 201, 202, 208, which passes shielding gas from a tank 101, via a regulator valve 102, to a discharge nozzle of the welding apparatus welding gun. An adjusting unit 113 provides an operator with an interface which permits adjustment of the parameters that determine the flow rate function.